

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 39887  
Estimate Number : 10831  
P.O. Number :  
This Issue : 16/06/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : MACHINED PARTS  
Previous Run : 34783  
Written By :  
Checked & Approved By : J. D. O. S. L. L.  
Comment : Est: B 00.06.26 New DWG rev, (mpp 2069) EC  
Est Rev: C As per Rev C 07-03-19 JLM

<b>Drawing Name</b>	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE				
<b>Part Number</b>	: D29321				
<b>Drawing Number</b>	: D2932 REV C				
<b>Project Number</b>	: N/A				
<b>Drawing Revision</b>	: C				
<b>Material</b>	:				
<b>Due Date</b>	: 04/07/2008	<b>Qty:</b>	6	<b>Um:</b>	Each

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 D6101003 Saddle Billet, 7075



**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 6.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: ~~B 33791~~ B 33792

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

### 5-Deburr & TUMBLE

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



**Comment:** INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/06/2008 10:25:26 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 39887

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mf 08/06/27*

*(6)*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*BR / RP 08/07/01*

*(6)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

*7:40*

OVEN TEMPERATURE:

*320*

FINISH TIME:

*8:00*

*BR / RP 08/07/02*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*508/07/02 (+6)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *428*

*8/7/2*

*(6x)*

*SP*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/03*

Job Completion



*mf 08-07-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39887
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.125	0.123	0.125	0.126		
B	0.100	0.140		0.125	0.123	0.122	0.126		
C	0.100	0.140		0.120	0.125	0.127	0.136		
D	0.210	0.230		0.220	0.218	0.218	0.218		
E	1.245	1.255		1.248	1.249	1.250	1.250		
F	1.245	1.255		1.249	1.249	1.249	1.250		
G	2.495	2.505		2.500	2.500	2.501	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.575	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.260	0.260	0.260	0.260		
L	0.312	0.317		0.316	0.316	0.3155	0.316		
M	0.235	0.240		0.2385	0.238	0.238	0.238		
N	0.100	0.140		0.120	0.118	0.118	0.118		
O	0.540	0.560		0.541	0.549	0.550	0.5515		
P	0.490	0.510		0.499	0.494	0.490	0.495		
Q	3.715	3.725		3.718	3.7185	3.719	3.719		
R	2.470	2.510		2.497	2.497	2.497	2.497		
S	0.240	0.270		0.2475	0.250	0.247	0.2485		
T	0.100	0.180		0.135	0.135	0.135	0.140		
U	1.625	1.635		1.628	1.630	1.630	1.630		
V	1.362	1.372		1.365	1.367	1.367	1.367		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.125	1.145		1.1345	1.134	1.1325	1.1335		
Y	1.565	1.585		1.5745	1.574	1.5725	1.5725		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>DT</i>
Date: 08/06/26

Audited by: <i>[Signature]</i>
Date: 08/06/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39887
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C	<b>Page 1 of 1</b>

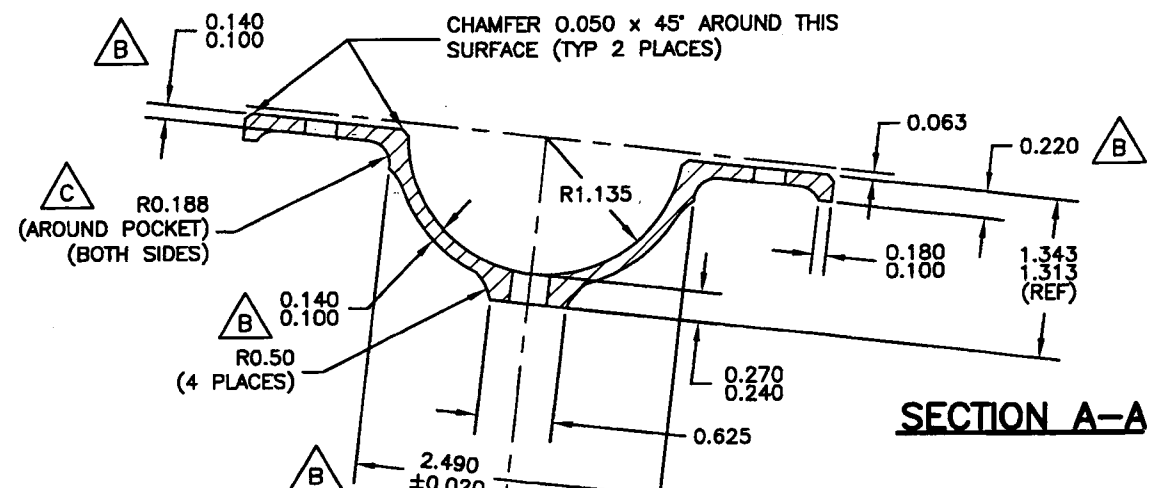
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.100	0.140		0.124	0.125				
B	0.100	0.140		0.123	0.125				
C	0.100	0.140		0.130	0.130				
D	0.210	0.230		0.217	0.217				
E	1.245	1.255		1.250	1.2485				
F	1.245	1.255		1.250	1.249				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.511	0.511				
I	1.572	1.582		1.576	1.575				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.260	0.260				
L	0.312	0.317		0.316	0.316				
M	0.235	0.240		0.238	0.238				
N	0.100	0.140		0.118	0.118				
O	0.540	0.560		0.5515	0.551				
P	0.490	0.510		0.500	0.496				
Q	3.715	3.725		3.720	3.719				
R	2.470	2.510		2.497	2.498				
S	0.240	0.270		0.248	0.248				
T	0.100	0.180		0.140	0.140				
U	1.625	1.635		1.630	1.629				
V	1.362	1.372		1.366	0.3665				
W	0.316	0.321		0.321	0.321				
X	1.125	1.145		1.133	1.134				
Y	1.565	1.585		1.5725	1.5735				
Z	0.178	0.198		0.188	0.188				
AA									
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AG									
AH									
Accept/Reject									

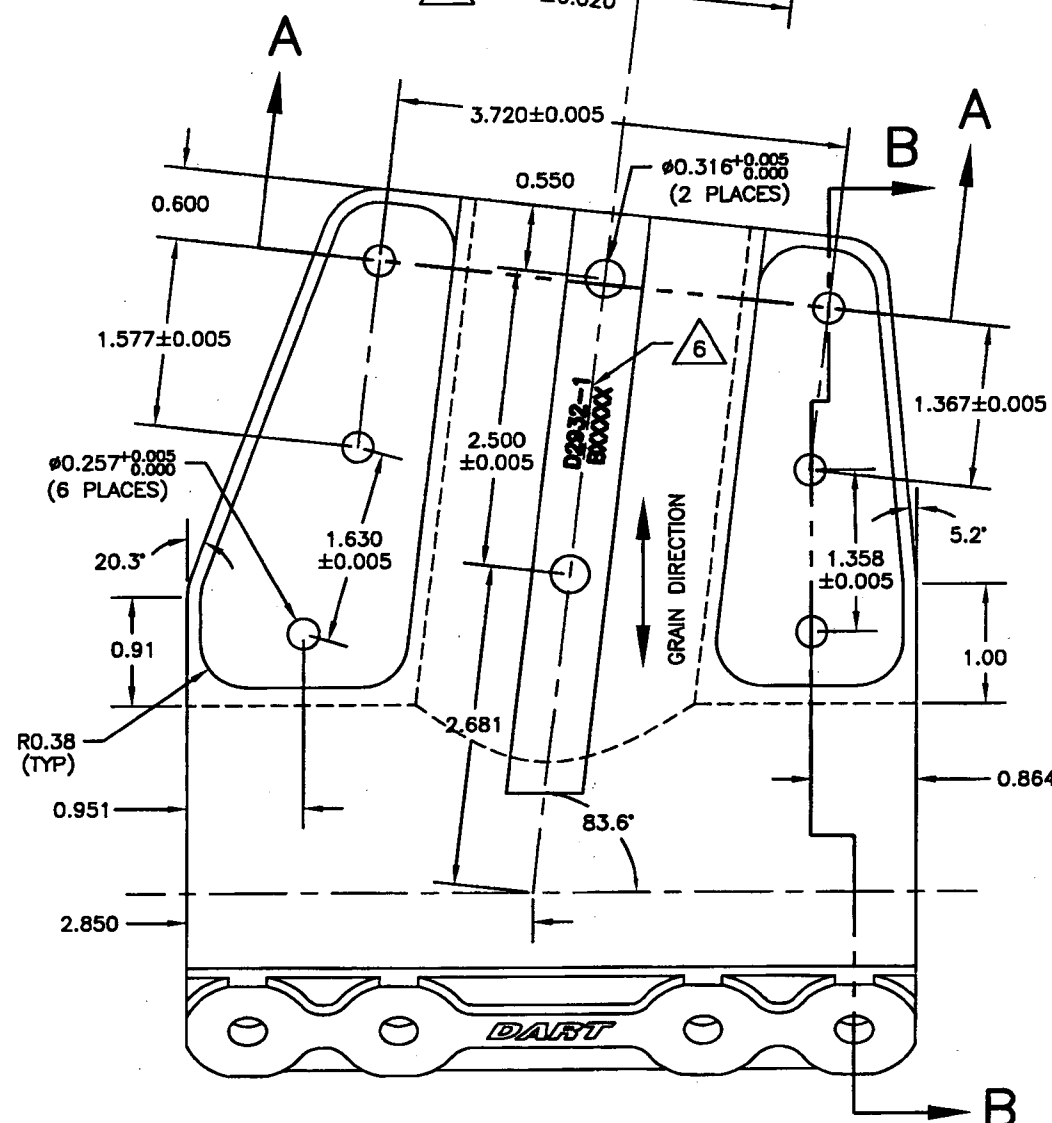
Measured by: <u>DTD</u>
Date: <u>08/06/27</u>

Audited by: <u>mf</u>
Date: <u>08/06/27</u>

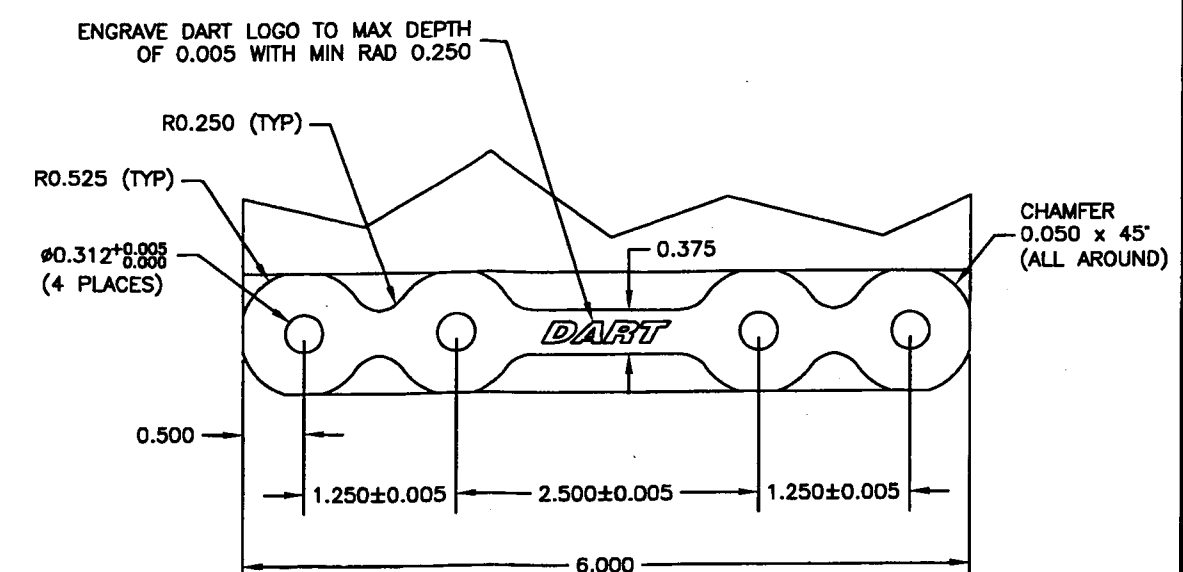
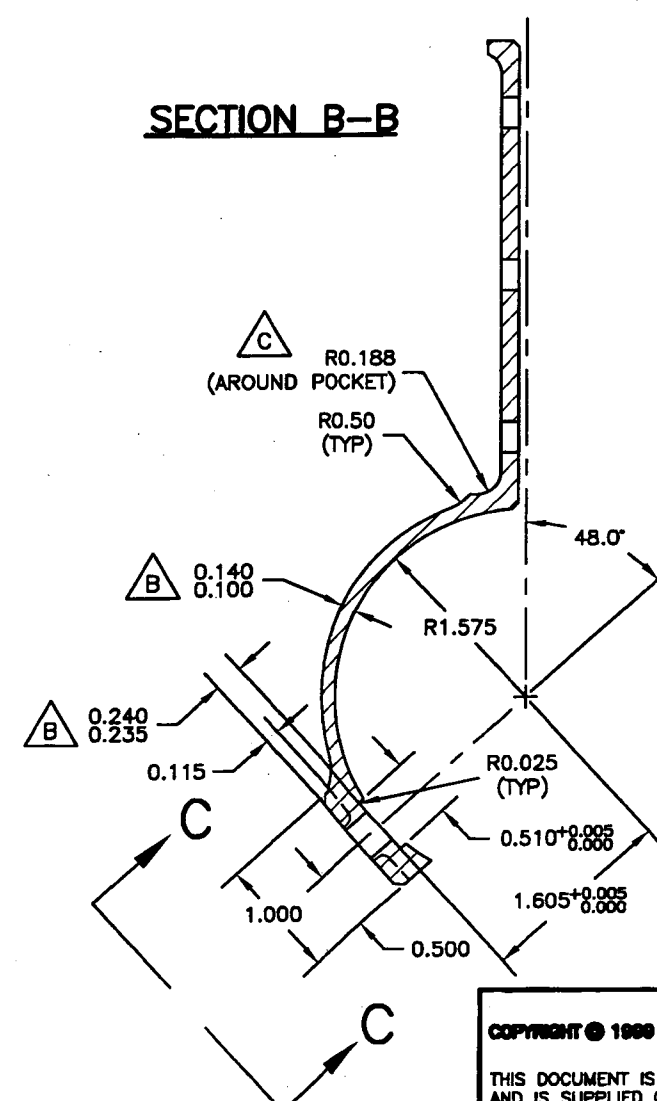
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 391857

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE		TITLE SADDLE OUTSIDE
06.11.09		SCALE 2:3

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RELEASED  
07-02-12